

ASAP

Date: Monday, 7/16/2007 2:43:57 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JOGGLE BRACKET
Job Number : 33549	
Estimate Number : 12912	
P.O. Number :	Part Number : D35801
This Issue : 7/16/2007 S.O. No. :	Drawing Number : D3580 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33145	Material :
Written By :	Due Date : 7/23/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 07.06.25 EC	
Est Rev: B Removed Powder Coat 07-07-11 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S18GA	304/316 .050 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.2100 sf(s)

304/316 SS sheet 0.050" thick

Batch: *M/00997*

SAD

07/07/20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

SAD

07/07/20

(21)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/07/20

(21)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/07/20

(21)

5.0	SMALL FAB 1--	SMALL & MEDIUM FAB RESOURCE 1
-----	---------------	-------------------------------



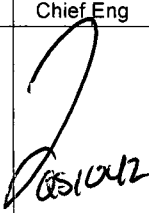
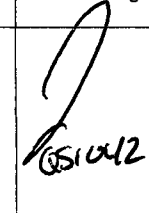
Comment: Bend as per dwg D3580 using 1/8" offset die

07/08/13

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3580-1 PAR #: N/A Fault Category: Prod - Sm Fab NCR: Yes No DQA: HA Date: 07.08.14
 QA: N/C Closed: HA Date: 07.08.21

NCR: <u>33549</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/13	#5.0	one part was found with the D.M. 0.62" at 0.550" (0.076") too small. Part was bent wrong R.C. Hammerman Error	 05/04/12	Scrap and destroy and No Replace	SB 07/07/13	Er 07/08/13	 05/04/12	Er 07/08/13

NOTE: Date & initial all entries

Date: Monday, 7/16/2007 2:43:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 33549

Part Number: D35801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/08/03 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF/09

7/8/14 SP

(20x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

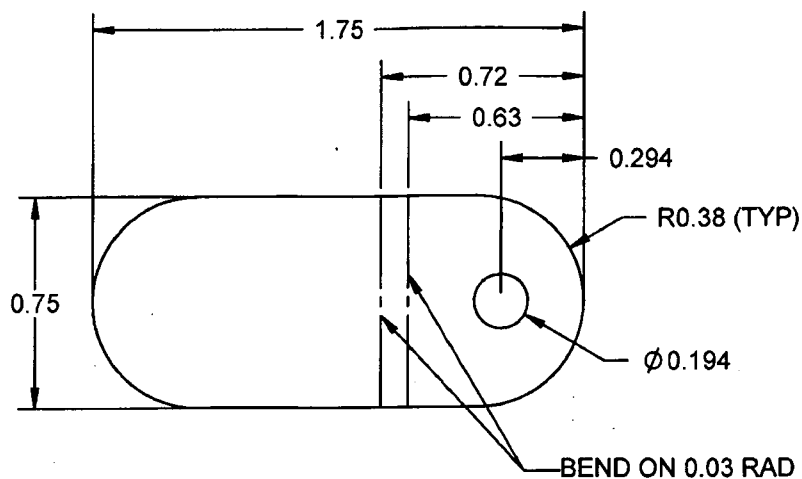
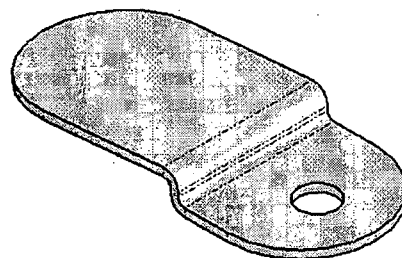
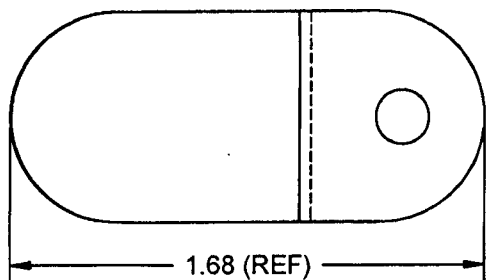
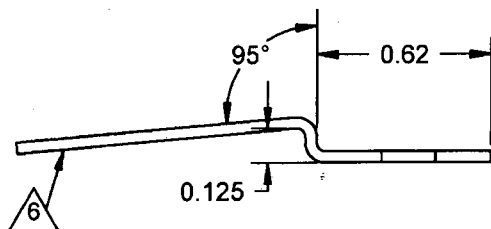
Job Completion



C207/08114

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED07.07.09 *[Signature]***D3580-1F FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3580-1 JOGGLE BRACKET**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) NO. _____
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

